

# Work Order ID 63462

November 2, 2010 12:56:21 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CG Date: 10/11/02 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2445/D350-588	Rev D/D
----------------	---------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

8 10/12/13

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12854  
Description: D2445 Baggage Door  
Supplier: Delastek  
Ship to Delastek (1) D0588-041 label  
Certification of Conformity and process sheet from Delastek is required.

CG 10/11/03 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D350-588-041

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Setup Start

Revision ID:

Stop

Item Name: Aft Door Assembly

Start Date: 11/02/10 Start Qty: 1.00

Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity &amp; Process Sheet are attached

11/12/03 (1)

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.  
Audit process sheet.

S 10/12/06

(10)

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

10-12-04 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



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Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
155  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
160  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 11/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: 43

0.00

*REV D*

10/12/13

*[Signature]*



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

10/12/13

*ME*

10-12-13



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 63462

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly



Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04 Reformat KJ/DS  
per DS19414 DD verified by:EC  
10.03.29 verified by:EC  
IPP Rev:Q as  
IPP Rev:R add pick kit DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P 		Purchased	No			110	Each	0.0000	1	1			
AFT DOOR ASSEMBLY						B63462						10-12-06	
AN526C832R9 		Purchased	No			140	Each	149.0000	8	8			
Screw												10-12-06	

Location	Loc Qty	Loc Code
ST327	149	
115422	3	
115835	46	
115936	100	

AN960JD10 	NAS1149D0363J	Purchased	No			140	Each	8.0000	2	2			
Washer						M115622						10-12-06	

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

AN960JD8 	NAS1149DN832	Purchased	No			140	Each	10.0000	8	8			
Washer						M116025						10-12-06	

Location	Loc Qty	Loc Code
ST347	10	
105059	10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63462



Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2143 Manufactured No

140 Each

10.0000 1 1



Hinge Bracket



RT 10-12-06

Location

Loc Qty

Loc Code

ST198

10

55323

10

D2144 Manufactured No

140 Each

35.0000 1 1



Hinge Bracket



RT 10-12-06

Location

Loc Qty

Loc Code

ST198

35

55179

35

D2463 Manufactured No

140 f

486.1100 7.25 7.25



Seal



RT 10-12-06

Location

Loc Qty

Loc Code

ST404

486.11

55561

1.68

62597

484.43

(D2463-0870) cut (1) at 87.00"  
\*\*\*\* per kit\*\*\*\*

D2585 Manufactured No

140 Each

50.0000 2 2



Mounting Channel



RT 10-12-06

Location

Loc Qty

Loc Code

ST018

33

62676

33

ST019

17

59873

17

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63462

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No 140 Each 52.0000 2 2  
  
 Door Latch

Location Loc Qty Loc Code

ST204 52  
 61655 52

D2621 Manufactured No 140 Each 67.0000 2 2  
  
 Latch Plate, 350 Spacepod

Location Loc Qty Loc Code

ST021 67  
 46842 7  
 56526 60

D2857-1 Manufactured No 140 Each 28.0000 1 1  
  
 Hinge Bracket

Location Loc Qty Loc Code

ST026 28  
 56529 5  
 57924 23

D2857-2 Manufactured No 140 Each 32.0000 1 1  
  
 Hinge Bracket

Location Loc Qty Loc Code

ST027 32  
 55020 1  
 56530 7  
 57925 24

BT 10-12-06

x2

BT 10-12-06

x2

BT 10-12-06

x2

BT 10-12-06

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 63462

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

160.0000

8

8



W116082



25 10 12 06

Nut

Location

Loc Qty

Loc Code

ST300

160

115835

160

MS21042L3

Purchased

No

140

Each

1,898.000

4

2



25 10 12 06

Nut

Location

Loc Qty

Loc Code

ST300

1898

114784

898

115835

1000

x 2

MS27039-1-15

Purchased

No

140

Each

47.0000

2

2



25 10-12-06

Screw

Location

Loc Qty

Loc Code

ST292

47

114056

2

114718

45

x 2

AN526C1032R7

Purchased

No

155

Each

46.0000

2

2



10/12/06

Screw

Location

Loc Qty

Loc Code

ST328

46

113064

1

113749

1

114056

44

2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

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Work Order ID: 63462



Parent Item: D350-588-041



Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

AN526C832R8

Purchased

No

155

Each

132.0000

8

8



Screw



10/12/6 sf

Location

Loc Qty

Loc Code

ST327

132

114615

32

114718

100

8

AN960JD10

NAS1149D0363J

Purchased

No

155

Each

8.0000

2

2



Washer



M115622 10/12/6 sf

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8

NAS1149DN832

Purchased

No

155

Each

10.0000

16

16



Washer



Should match on both

M116025 10/12/6 sf  
~~M116025 10/12/6 sf~~

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2150

Manufactured

No

155

Each

20.0000

2

2



Packer Doubler, Hinge



10/12/6 sf

Location

Loc Qty

Loc Code

ST007

20

55178

20

2

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/13	A 100						

Part No: D350-588-041 PAR #: \_\_\_\_\_ Fault Category: Prod Eng - Correct NCR: Yes ☒ No ☐ DQA: \_\_\_\_\_ Date: 10/12/13  
 Resolution: rework Disposition: rework QA: N/C Closed: ☒ Date: 11/02/07

NCR: <u>63462</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/13	A 100	Qty For A960558 washer is incorrect. Should be x16 per kit. Per IIN	<u>DS/11/2</u>	- correctly update Bom + wlo.	<u>N/A</u>	<u>11/02/07</u>	<u>DS/11/2</u>	<u>S</u> 10/12/13
		RC: Other: Intuitive print out error. on Intuitive everything was good		Bom was updated on the 10.01.22	<u>11.02.07</u>			
				Was a Intuitive error Intuitive error was updated				

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 63462

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2151

Manufactured No

155

Each

43.0000



Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST007

43

55319

5

62246

38

D2153

Manufactured No

155

Each

16.0000



Door Prop

Location

Loc Qty

Loc Code

ST272

16

59818

16

D2154

Manufactured No

155

Each

6.0000



Stud Bracket

Location

Loc Qty

Loc Code

ST007

6

55325

3

62479

3

D2237

Manufactured No

155

Each

52.0000



Striker Plate

Location

Loc Qty

Loc Code

ST009

5

60492

5

ST010

47

62212

47

2 2  
10/12/10 sf

1 2  
10/12/10 sf

1 1  
10/12/10 sf

2 2  
10/12/10 sf

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-588-041


Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

 D2461  
  
 Neoprene "D" Seal

Manufactured No

155 f

115.7072 7.25 7.25



*10/12/10*

Location

Loc Qty

Loc Code

ST402

115.7072105

39782

6.5

55054

109.207211

*7.25*

(D2461-0870) cut (1) at 87.00"  
 \*\*\*\* per kit\*\*\*\*

 D2589  
  
 Keys, Key Chain, 350 Hinge

Manufactured No

155 Each

161.0000



*10/12/10*

Location

Loc Qty

Loc Code

ST019

161

58194

161

155 Each

16.0000



*2*

 D2690-17  
  
 Cable

Manufactured No

155 Each

16.0000



*10/12/10*

Location

Loc Qty

Loc Code

ST021

16

62480

16

155 Each

15.0000



*10/12/10*

 D2858-1  
  
 Hinge Bracket

Manufactured No

155 Each

15.0000



Location

Loc Qty

Loc Code

ST027

15

56423

9

61522

6

*1*

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W/O:		WORK ORDER CHANGES					
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Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

D2858-2

Manufactured No

155

Each

7.0000

1

1

Hinge Bracket

LocationLoc QtyLoc Code

ST027

7

56048

1

61523

6

FG-778150-550-ROL

Purchased

No

155

sf

1,840.750

1

7781 9oz Glass 50"x125yd

LocationLoc QtyLoc Code

ST404

1840.75

108932

18

111166

397

113905

1425.75

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No

155

Each

5,984.000

12

RIVET

LocationLoc QtyLoc Code

ST316

5984

104374

1984

110398

4000

MS20470AD4-5

Purchased

No

155

Each

526.0000

18

18

Rivet, Universal Head

LocationLoc QtyLoc Code

ST309

461

114761

461

ST319

65

111916

65

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 63462

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 11/02/10

Required Date: 11/19/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

155

Each

160.0000

10

10



Nut

Location

Loc Qty

Loc Code

ST300

160

115835

160

MS21042L3

Purchased

No

155

Each

1,898.000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

1898

~~114784~~

898

115835

1000

MS27039-08-11

Purchased

No

155

Each

45.0000

2

2



Screw

Location

Loc Qty

Loc Code

ST288

45

114382

45

2

November 2, 2010 12:56:21 PM

Shop Packet Print

Page 9

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

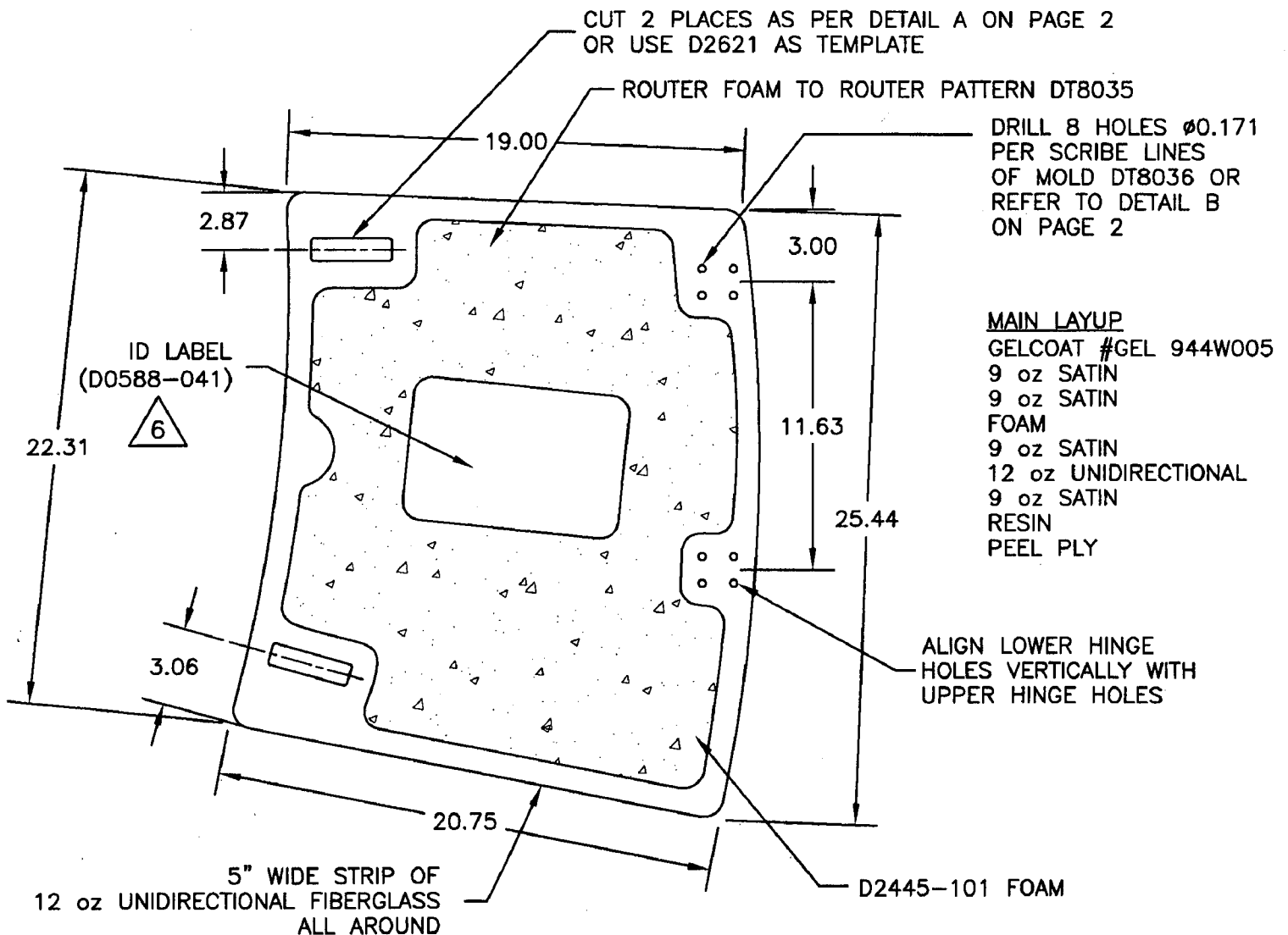
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/12/13	100	Qty for ms21042606 is incorrect. should be @ 100000 lit. to 1200.		-update w/o to Bom				S 01/12/13

NOTE: Date & initial all entries

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

**RELEASED**06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

C21011102

W10:63462

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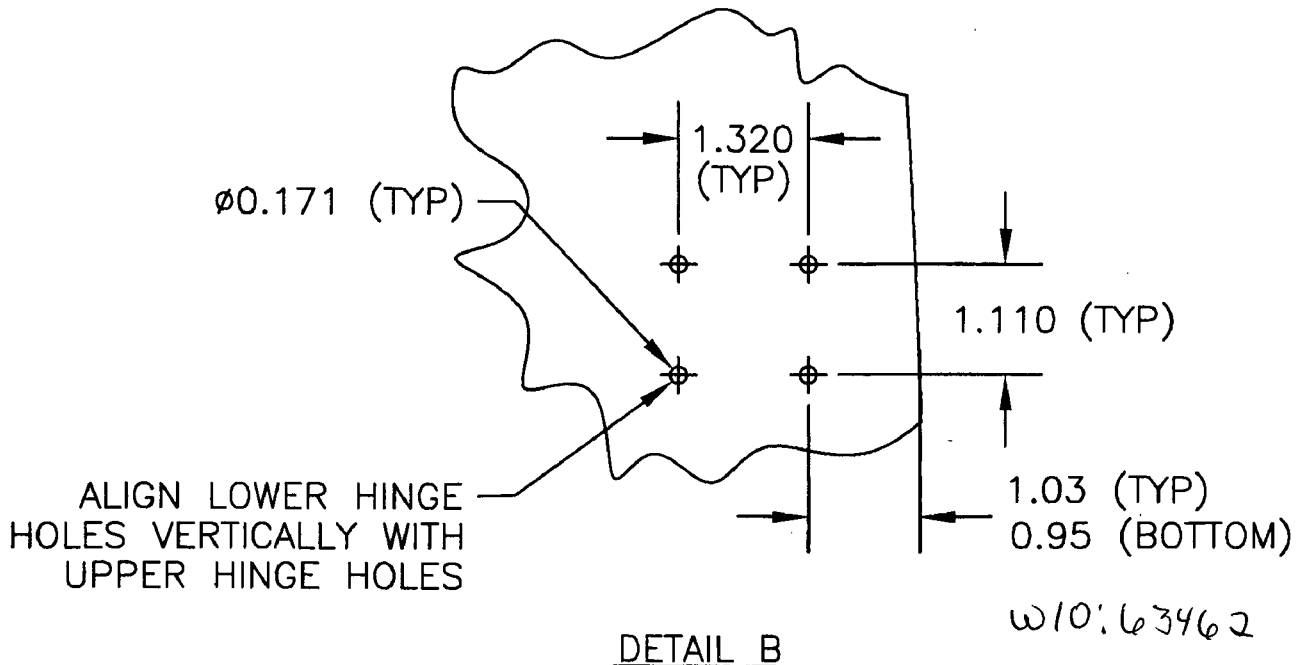
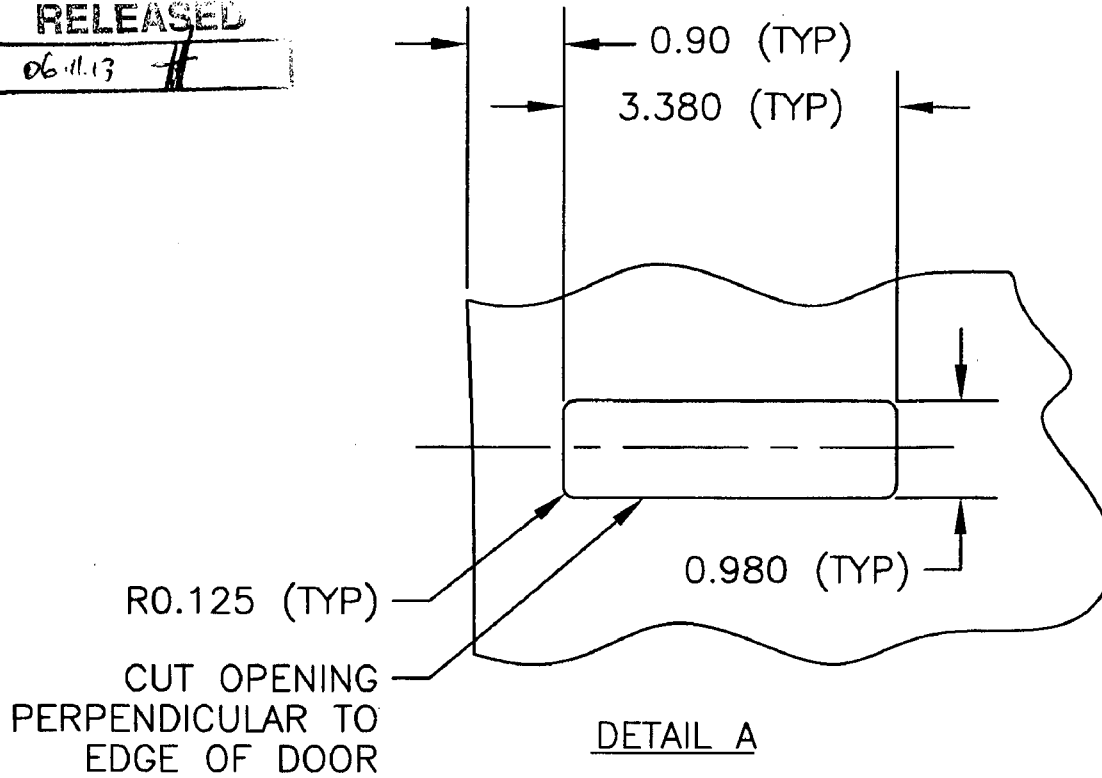
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**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2445</b>	REV. D SHEET 2 OF 2
DATE <b>06.06.09</b>		TITLE <b>AFT BAGGAGE DOOR</b>	SCALE <b>1:2</b>

RELEASED

06.11.13 *[Signature]*



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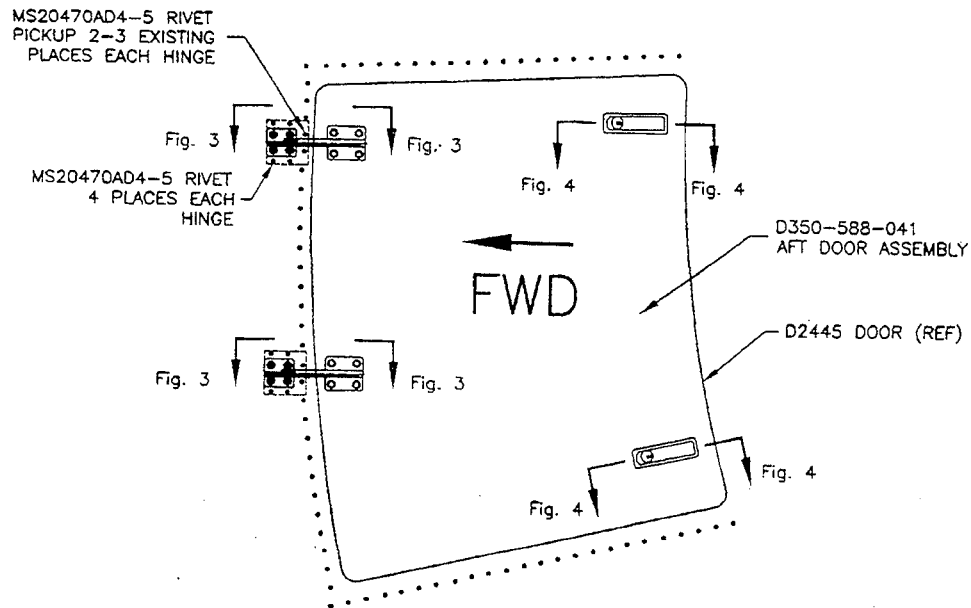


Figure 2: Baggage Door Outside View

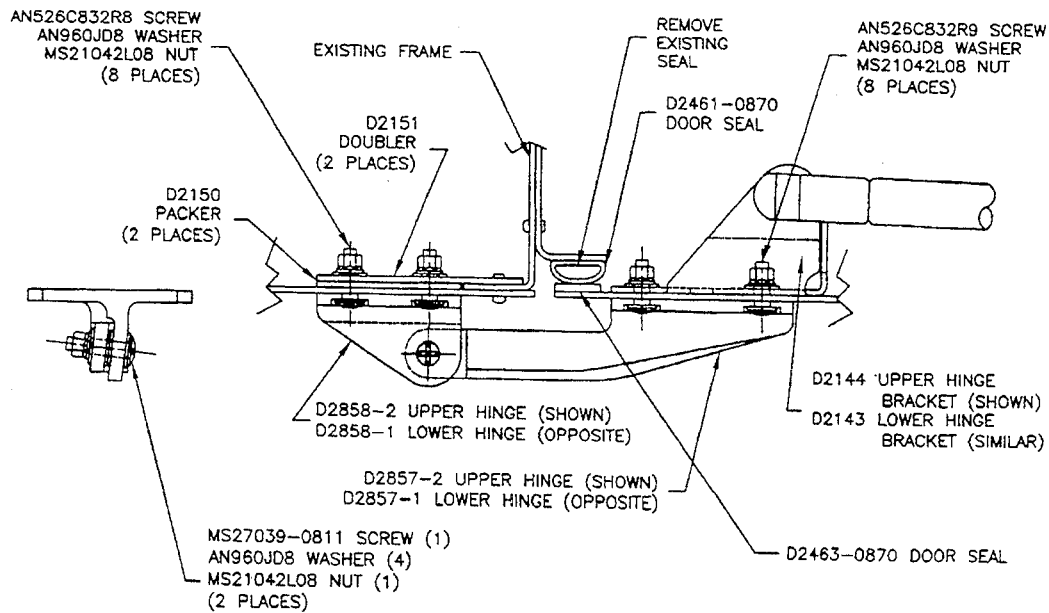


Figure 3: Hinge Detail

w10: 63462

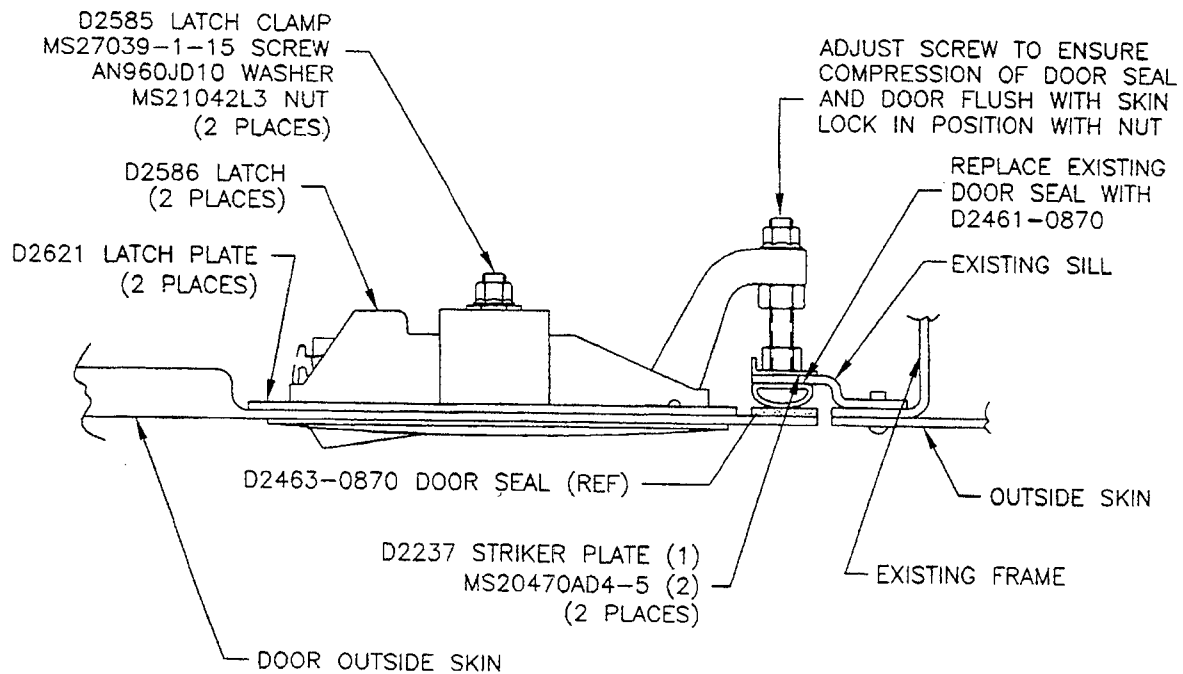
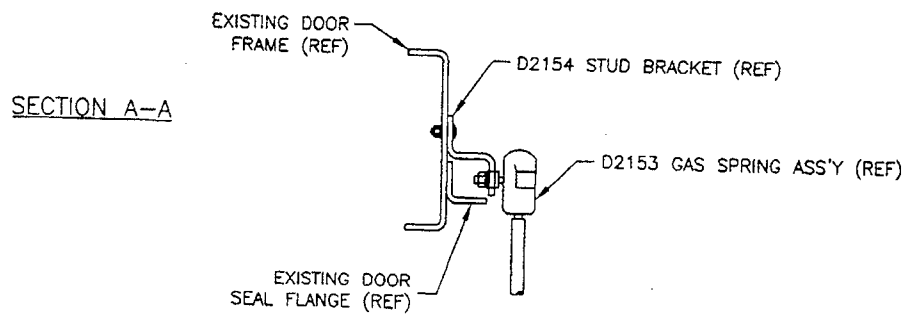
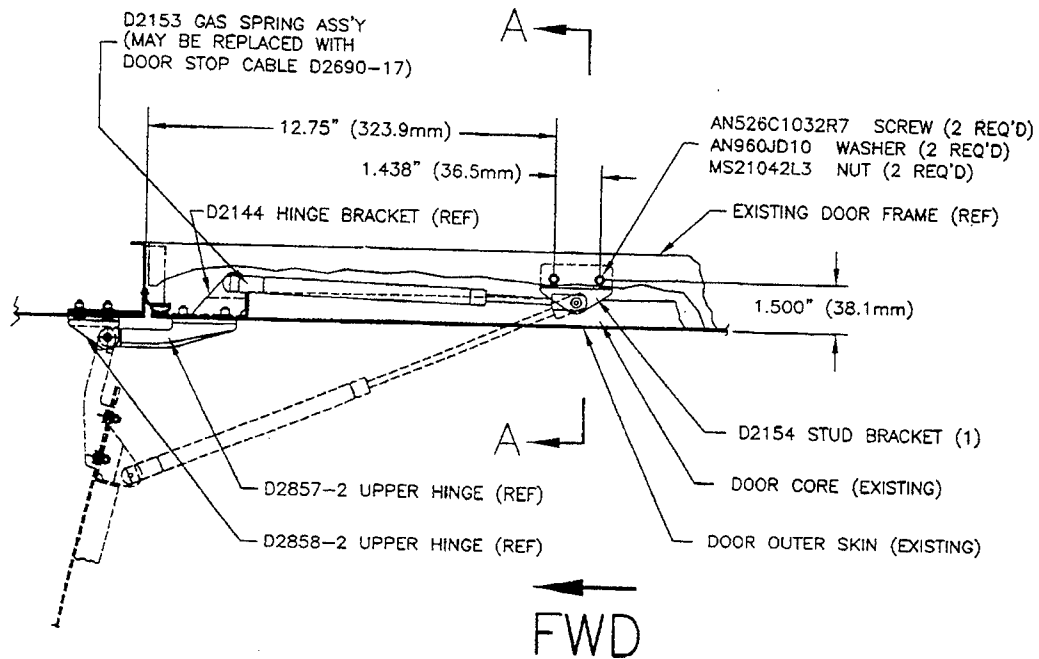


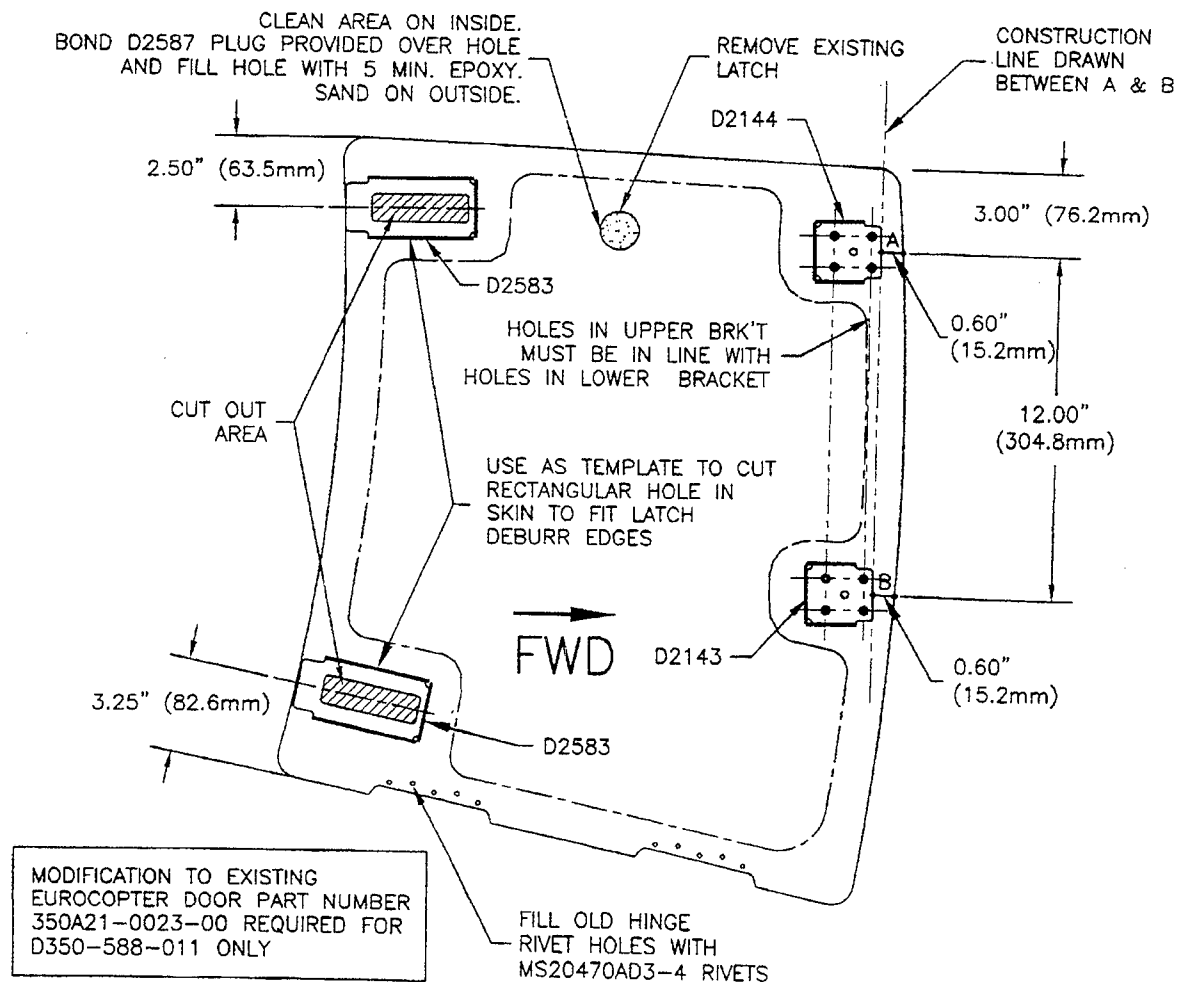
Figure 4: Latch Section

W10'63462



W10:63462

Figure 5: Gas Spring Installation



010:63462

Figure 6: Baggage Door Inside View



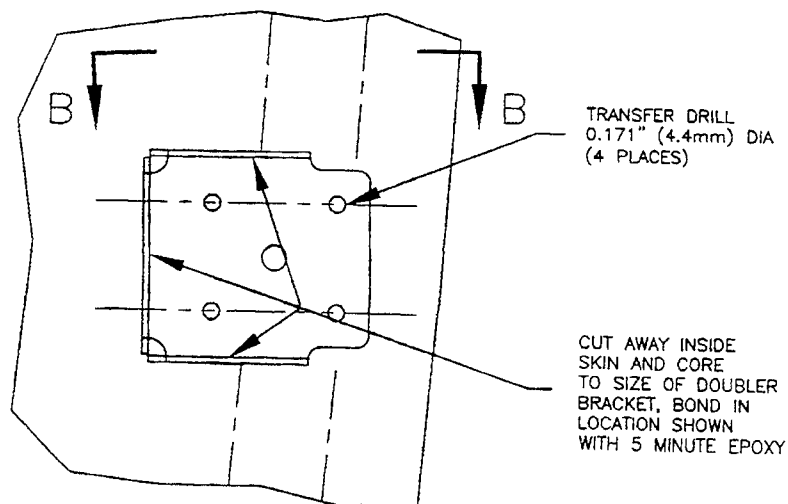
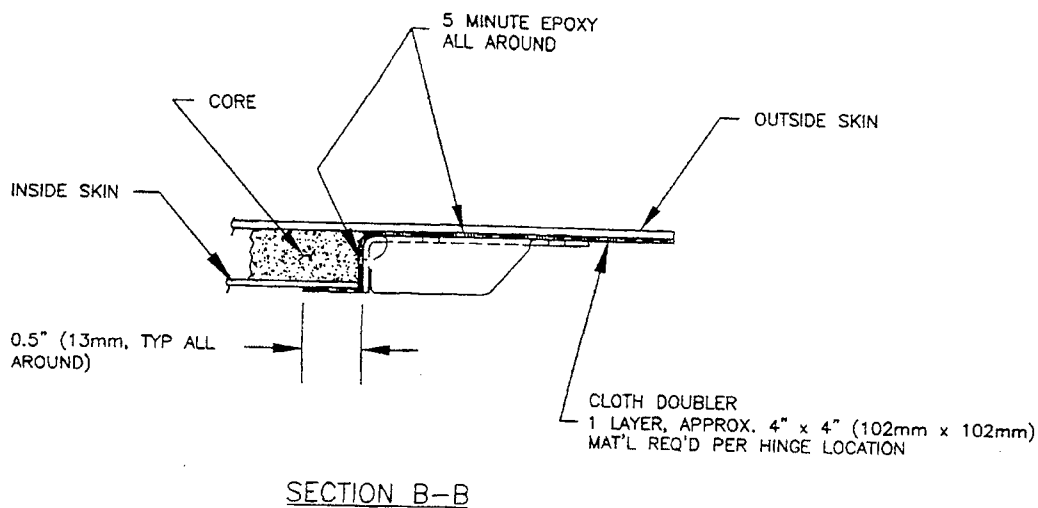


Figure 7: Typical Doubler Bracket Installation

W10.63462

3.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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Revision: D  
Date: 02.01.17

W10.63462



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO12854**

Purchase Order Date 11/03/10

PO Print Date 11/03/10

Page Number 1 of 2

**Order From :**

VU-DEL003

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 123

GRAND-MERE, QC G9T 5K7  
CA

**FAKED**  
*6/14/13*

**Contact Name**

**Vendor Phone**

819 533 5788

**Vendor Fax**

819 533 3494

**Vendor Account Nbr**

**Buyer**

Chantal Lavoie

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

USD

**FOB**

Destination-Collect

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2445P	AFT DOOR ASSEMBLY	12/03/10 Yes	✓ 1.00 Each	Purolator ground	\$580.0000	\$580.00
			<i>6/14/13</i>				
<b>Special Inst:</b>			AS PER DWG D 2445 REV. D B63462				
2	D2445P	AFT DOOR ASSEMBLY	12/03/10 Yes	1.00 Each	Purolator ground	\$580.0000	\$580.00
<b>Special Inst:</b>			AS ABOVE B63463				
3	D2445P	AFT DOOR ASSEMBLY	12/10/10 Yes	1.00 Each	Purolator ground	\$580.0000	\$580.00
<b>Special Inst:</b>			AS ABOVE B63464				
4	D2445P	AFT DOOR ASSEMBLY	12/10/10 Yes	1.00 Each	Purolator ground	\$580.0000	\$580.00

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 11/03/10



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

**Telephone:** (819) 533-5788  
**Warehouse:** MAIN

<b>Invoice #</b>	36213
<b>Customer #</b>	DART US

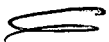

**Bill to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Telephone:** 613-632-5200  
**Contact:** Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
02/12/2010	03/11/2010	15934	Chantal Lavoie		PO12854		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013   	D350-588-041 Aft Baggage Door (D2445) B63462 U de M : Each Drawing N° : D2445 Rév.: D  <div><u>No. série</u> B63462</div> <div><u>No. lot</u> 30100</div>			

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by: *[Signature]*

Quality department

AQ-357



Date: Jeudi, 2010-11-04 12:54:20  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: N° D2445, AFT BAGGAGE DOOR
Numéro Job	: 30100	Numéro Article	: DKC134-0013
Numéro Soumission	: 3959	Numéro Dessin	: D2445
Numéro B.A.	:	Projet Numéro	: DKC134
Cette fois	: 2010-11-04	Révision dessin	: D
Prsht Rev.	: NC	Matériel	: Composite
Prem. fois	: - -	Date Dûe	: 2010-11-10
Job précédente	: 26400	Qté:	1 Udm: UNITE
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D2445		

Process Sheet Rév.: 00 Création du premier dans DKA à partir de la  
Rév.: 10 de DKC

B 63462

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.20 UNITE(s)/Unit Total : 0.20 UNITE(s)

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009

Date: \_\_\_\_\_ Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-28605-1

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

5.0 AC0747 Acetone

Commentair Qty.: 0.130 KILOGRAMME(s)/Unit Total : 0.130 KILOGRAMME(s)

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 4-11-10 Sceau:  Temps Début: \_\_\_\_\_ Temps Fin: \_\_\_\_\_

Date: Jeudi, 2010-11-04 12:54:21  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30100

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 4/11/10 Sceau:  Temps Début:        Temps Fin:       

8.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

9.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

10.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

11.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

12.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-26697-1

13.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-22649-1

14.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

15.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: Jeudi, 2010-11-04 12:54:21  
Utilisateur: Pascal Carignan

## Feuille de Procédé


Client: DART US DART AEROSPACE LTD  
Numéro Job: 30100

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

Date: 12-5-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: 

16.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-22176-1

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-28751-1

18.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 5-11-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: 

19.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 5-11-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  



20.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher à l'air ambiant pendant 4 heures minimum.

Date: 5-11-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  

Curing début: 9:30 Curing Fin: 4:00 (8-11-10)

Date: Jeudi, 2010-11-04 12:54:21  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30100

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

21.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-221761

22.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-28751-1

23.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préaération de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 5-11-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

24.0 AAC1611 Polybond B46F

Commentair Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)  
Polybond B46F N° de Lot: 1-26580-1

25.0 DKC134-0029 Foam Core N° D2445-101 ( Pour AFT Baggage Door )

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Foam Core N° D2445-101 ( Pour AFT Baggage Door ) N° de Job: 26405

26.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Assembler le DKC134-0029 selon IG 0033

Date: 8-11-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

27.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher à l'air ambiant pendant 2 heures minimum.













Date: 8-11-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

Curing Début: 1:55 Curing Fin: 4:00



Date: Jeudi, 2010-11-04 12:54:21  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 30100		Numéro Article: DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
28.0	AMB0286	Catalyst N° DDM-9	
Commentair Qty.: 0.1360 GALLON(s)/Unit Total : 0.1360 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-22176-1</u>			
29.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Commentair Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-28751-1</u>			
30.0	PREP-GENERAL	Préparation du matériel	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.			
Date: <u>10-11-10</u> Heure Début: _____ Heure Fin: _____ Sceau: 			
31.0	LAMINAGE	Faire le laminage	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le laminage d'un pli de 9.7 oz.			
Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent			
Faire le laminage du dernier pli de 9.7 oz.			
Date: <u>10-11-10</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
32.0	BAGGING	Faire le bagging sur la pièce	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la poche à vide selon IG 0012			
Laisser sécher à l'air ambiant pendant 4 heures minimum.			
Date: <u>10-11-10</u> Heure Début: _____ Heure Fin: _____ Sceau:  			
Curing Début: <u>2:05</u> Curing Fin: <u>8:00</u>			

Date: Jeudi, 2010-11-04 12:54:21  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30100

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

33.0 DÉMOULAGE Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce selon IG 0018

Date: 16-11-10 Heure Début: ——— Heure Fin: ——— Sceau:

34.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 16-11-10 Heure Début: ——— Heure Fin: ——— Sceau:

35.0 AAC1605 Label N° D0588-041

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Label N° D0588-041 N° de Lot: 1-28975-1

36.0 AAC1609 Surface Veil

Commentair Qty.: 0.07 VERGE(s)/Unit Total : 0.07 VERGE(s)  
Surface Veil N° de Lot: ———

37.0 AAC1220 Résine Mia-Poxy 100

Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)  
Résine Mia-Poxy 100 N° de Lot: 1-25679-1

38.0 AAC1221 Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s)  
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-25679-2

39.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller le abel N° D0588-041 selon IG 0111.

Laisser scher pendant 4 heures.

Date: 19/11/10 Heure Début: ——— Heure Fin: ——— Sceau:

Date: Jeudi, 2010-11-04 12:54:21

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 30100

Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description:

40.0 AAC1390 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.025 KIT(s)/Unit Total: 0.025 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-26644-1

41.0 AAC1617 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.02 UNITE(s)/Unit Total: 0.02 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot: \_\_\_\_\_

42.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 19 nov 10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



43.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-28050-2

44.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-28382-1

45.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation et l'application du primer selon I.G. 0008

Quantité: 1 Date: 21 nov 10 Sceau: \_\_\_\_\_



Quantité: 1 Date: 24 nov 10 Sceau: \_\_\_\_\_



46.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 30 nov 10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



47.0 EMBALLAGE Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: Jeudi, 2010-11-04 12:54:21  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 30100

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: 1 Date: 1/dec 10 Sceau: L.B

## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
<del>1</del>	<del>1</del>	<del>D2143</del>	<del>HINGE DOUBLER</del>
<del>1</del>	<del>1</del>	<del>D2144</del>	<del>HINGE DOUBLER</del>
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
<del>1</del>	<del>1</del>	<del>D2445</del>	<del>DOOR</del>
1	1	D2461-0870	NEOPRENE D SEAL
<del>1</del>	<del>1</del>	<del>D2463-0870</del>	<del>1/2" FOAM SEAL</del>
	2	D2583	LATCH BRACKET
<del>2</del>	<del>2</del>	<del>D2585</del>	<del>LATCH CLAMP</del>
<del>2</del>	<del>2</del>	<del>D2586</del>	<del>LATCH</del>
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
<del>2</del>	<del>2</del>	<del>D2621</del>	<del>LATCH PLATE</del>
1	1	D2690-17	CABLE, DOOR STOP
<del>1</del>	<del>1</del>	<del>D2857-1</del>	<del>LOWER HINGE BRACKET</del>
<del>1</del>	<del>1</del>	<del>D2857-2</del>	<del>UPPER HINGE BRACKET</del>
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
<del>8</del>	<del>8</del>	<del>AN526C832R9</del>	<del>SCREW (or AN526-832R9)</del>
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
16	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2 /
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
<del>2</del>	<del>2</del>	<del>MS27039-1-15</del>	<del>SCREW</del>
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

## REFERENCE

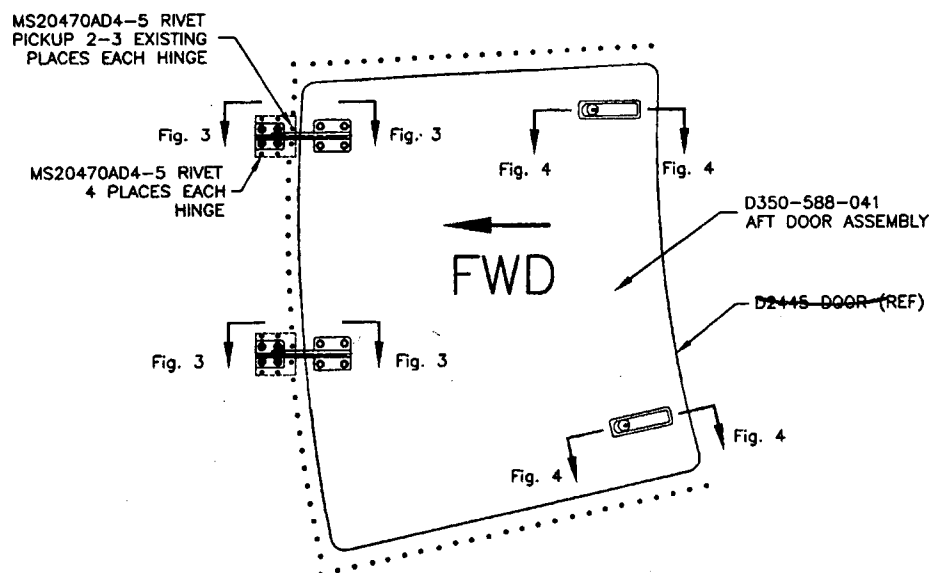


Figure 2: Baggage Door Outside View

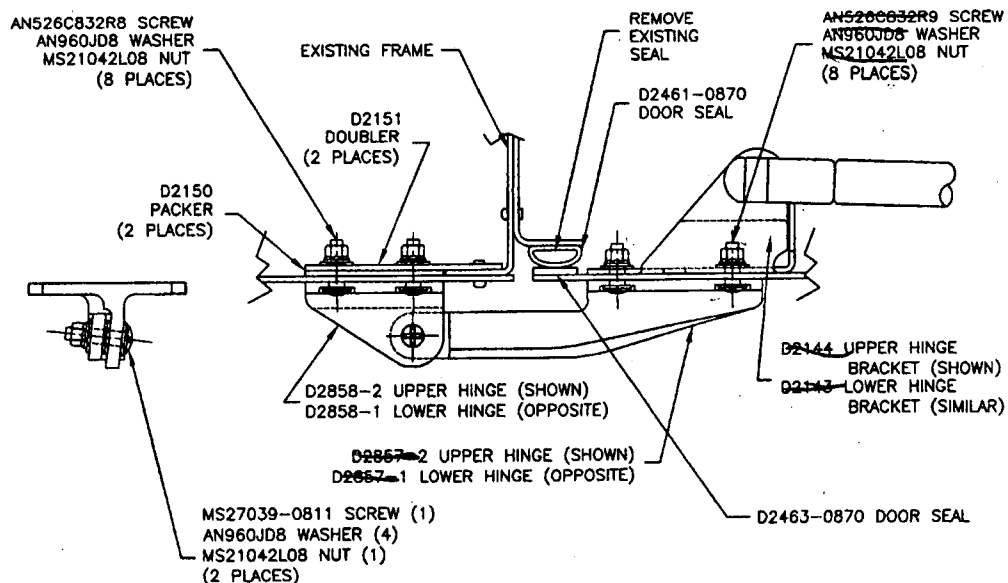


Figure 3: Hinge Detail

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Revision: D

Date: 02.01.17

## REFERENCE ONE.

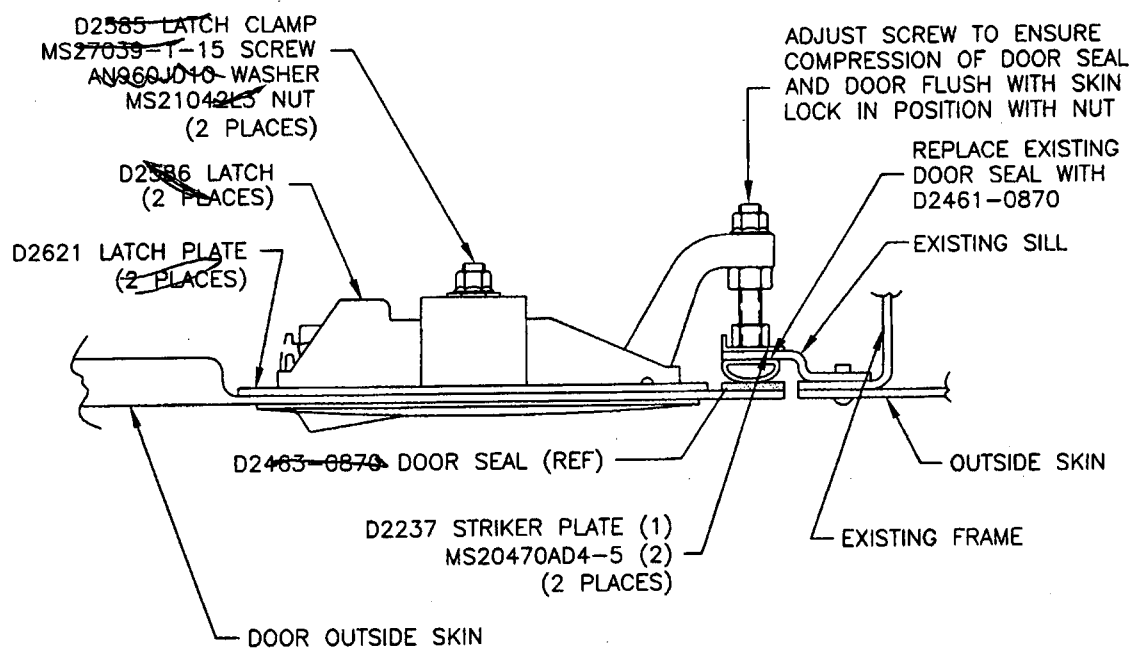


Figure 4: Latch Section

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